

Splut

Work Order ID 86617-1

Friday, July 06, 2012 10:12:36 AM

86617

Page 1

Item ID: D4522-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Base Plate, OEM, LH

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-07-06 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4522

B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

6061 .125

Prog Rev: B

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-7-11

B12-7-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/12/11

③ PD 12-07-11

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

1-COUNTER SINK AS PER DWG

2-REAM HOLE USING .625" REAMER

→

12-07-17

12-07-17

3X

3

12/5/11

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

DAS 16 12/6/17

③

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

151

0.00

151

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

ENGRAVE AS PER DWG AND FOLIO FB083

L.A 12/10/22

FOLIO REV: AA

DWG RE: B

2

0

152

QC5- Inspect part completeness to step on W/O

0.00

152

QC

Memo

0.00

Quality Control

Smb
12-10-22

0

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

2

2/10/12-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

2x0

MA
12/10/25

174

Gloss Grey (4.3.5.15) per QSI 005 4.3

0.00

174

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320 °F
1:30

2x0

MA
12/10/25

176

QC3- Inspect Part Finish

0.00

176

QC

Memo

0.00

Quality Control

2x0

MA
12/10/25

W118533

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

Identify as per dwg & Stock Location **ST/11**

0.00

180

Packaging

Memo

0.00

Packaging

2x

Sp
12-10-26

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/10/29

12-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, July 06, 2012 10:12:36 AM

Page 1

Work Order ID: 86617

Parent Item: D4522-1

Parent Item Name: Base Plate, OEM, LH

Start Date: 7/5/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-01-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No			100	sf	33.2881	0.301	0.6336842		1. 1812-7-11	

Location

Loc Qty

Loc Code

MAT021

33.2880789

121473

33.2880789

121473

3

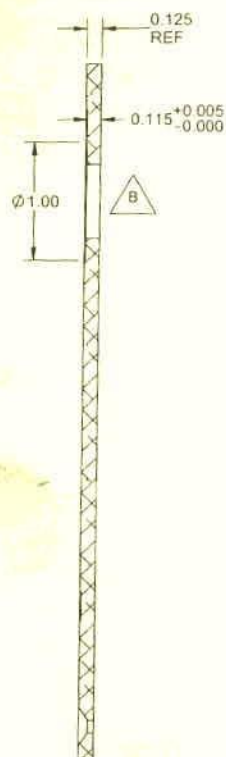
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

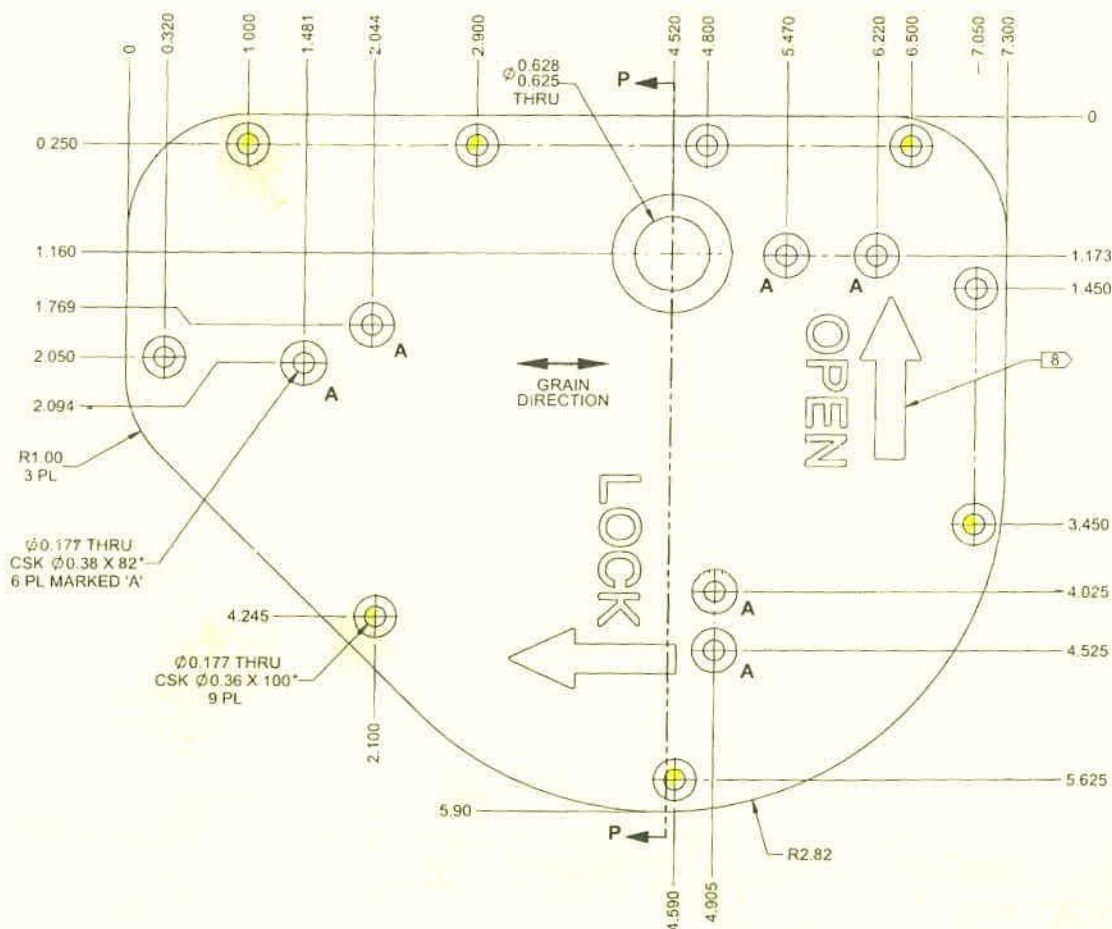
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SECTION P-P



NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209. REF M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT ANSI 61 (4.3.5.15) GREY PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.4 lbs
- 8) ENGRAVE TEXT AND ARROWS .010" DP IN APPROXIMATE LOCATION SHOWN. TEXT TO BE APPROX. 0.32 HIGH

D4522-1 BASE PLATE, OEM (LH)

RELEASED
2012-06-13

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4522	REV. B
MFG. APPR.			SHEET 7 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 86617
Description: BASE PLATE OEM LIT		Part Number:
Inspection Dwg: D4522-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .177	+ .005 - .001	.180	L		V	
Ø .625	+ .003 - .001	.625	1		V	
1.165	± .01	1.162	2		V	
1.769	± .01	1.769	L		V	
2.058	± .01	2.051	L		V	
2.094	± .01	2.093	2		V	
4.245	± .01	4.245	2		V	
5.90	± .01	5.907	L		V	
1.173	± .01	1.174	L		V	
1.450	± .01	1.448	L		V	
3.450	± .01	3.444	2		V	
4.025	± .01	4.025	2		V	
4.525	± .01	4.525	2		V	
5.625	± .01	5.620	L		V	
.320	± .01	.320	2		V	
1.006	± .01	.999	L		V	
1.481	± .01	1.481	2		V	
2.044	± .01	2.042	2		V	
2.906	± .01	2.904	2		V	
4.525	± .01	4.521	2		V	
4.800	± .01	4.801			V	
5.470	± .01	5.473	2		V	
6.220	± .01	6.222	2		V	

Measured by: B	Audited by: PD	Preliminary Approval:
Date: 12-7-11	Date: 12-01-11	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

11-1-17

16

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100

100 100